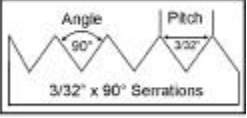


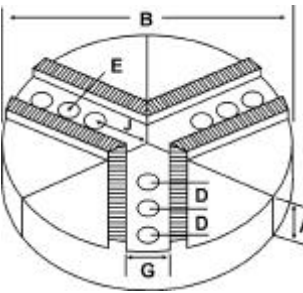
# ROUND JAWS- 3/32" x 90° Serrations

For Use On: SMW Autoblok, Forkardt, Rohm, Pratt Burnerd & Other Chucks



Group  
**13**

**WARNING!**  
Make Sure you are looking for Jaws with 3/32 x 90° serrations. Jaws using 1.5mm x 60° serrations may be found on pages 10-21.



- Round Jaws allow for complete gripping of workpiece.
- Oversized jaws available.
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece.
- Available in Aluminum, Cast Iron & Steel.
- Made in the USA.
- Maximum Length of Serrations 5.75".



### 3/32" x 90° Serration Jaws

Group No.	SMW Autoblok	Forkardt	Rohm	Chuck Size	Critical Dimensions				ALUMINUM				
					Groove Width G	Screw Size E	Hole Space D	Hole to Front J	Part Number	Price Set Of 3	Pie Dia B	Hght Inch A	No. of Holes
I3-100-138	HFK 400-500, HFKS 400-500, KDV 500	KG 400-500, KL 400-500, KLNC 400-500	KFD 400-500-630, KFD-HF 400-500, KFD-HS 400-500	16 - 20	1.004 (25.5mm)	20mm	1.380 (35mm)	3.500	15	2.50	3	RFK-16250A	393.27
										4.00	3	RFK-16400A	483.52
									21	2.50	3	21-RFK-16250A	719.47
I3-100-156	ALD-400,AND-400,BB 500-ES	-	-	16 - 20	1.000 (25.5mm)	3/4	1.562 (39.5mm)	3.250	15	2.50	3	RSM-16250A	393.27
										4.00	3	RSM-16400A	483.52
I3-118-250	-	-	-	25 - 32	1.181 (30mm)	1.00	2.500 (63.5mm)	4.250	21	4.00	2	RSM-21400A	899.87
									24	4.00	2	RSM-24400A	1252.35

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018. 18" & Larger- Aluminum Casting T6  
For complete list of applicable chucks, see pages 60-72. \* denotes non-stock item. Please allow 1 week manufacturing time.

## JAW BORING RING

No need to look all over the shop for a setup piece and waste time. Our jaw boring ring is essential for boring Soft Jaws and Round Jaws.

### Installation Instructions:

1. Place the jaw boring ring over your chuck and locate the boring ring pins in the counterbore of your chuck jaws.
2. Turn the jaw boring ring until snug.
3. Activate your jaws.

The jaw boring ring will apply equal pressure on all jaws, allowing for a consistent bore.



Hardened & Ground Boring Ring

Soft Jaws

### Jaw Boring Ring (comes complete with 3 pin assemblies)

Chuck Dia	ID Inch	OD Inch	Pin Depth	Pin Dia	Part Number	Price Each
6"	3.250	6.825	0.350"	0.512"	JBR-06	\$170.60
8"	3.500	8.450	0.350"	0.562"	JBR-08	\$209.70
10"	5.900	10.150	0.350"	0.709"	JBR-10	\$236.73
12"	7.475	12.075	0.400"	0.709"	JBR-12	\$263.18
15"	8.900	15.230	0.600"	0.938"	JBR-15	\$395.43

### Extra Pin Assemblies

Pin Depth Inch	Pin Dia. Inch	Indiv. Pins Part Number	Price Each	Pins-Set of 3 Part Number	Price Each
0.350"	0.512"	JBR-PIN-06	\$19.84	JBR-PIN-06-SET3	\$65.48
0.350"	0.562"	JBR-PIN-08	\$19.84	JBR-PIN-08-SET3	\$65.48
0.350"	0.709"	JBR-PIN-10	\$19.84	JBR-PIN-10-SET3	\$65.48
0.400"	0.709"	JBR-PIN-12	\$19.84	JBR-PIN-12-SET3	\$65.48
0.600"	0.938"	JBR-PIN-15	\$19.84	JBR-PIN-15-SET3	\$65.48

## CHUCK STOPS

This product is so useful and simple, you'll wonder why you never thought of it. The Royal chuck stop is a precision machined aluminum extrusion which mounts squarely against the face of almost any 3 jaw lathe chuck, providing a fixed reference surface for workpieces to locate against.



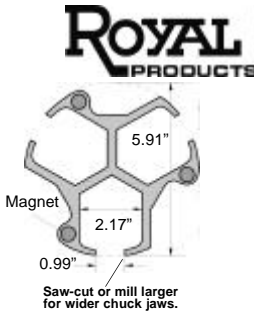
### FEATURES:

- Allows short parts to project past the chuck jaws, providing clearance for facing operations.
- Eliminates the need to bore soft jaws, reducing setup time.
- Front and rear locating surfaces are parallel within ±0.0004".
- 25mm slot width can be milled larger for chucks with wider jaws.
- Interlocking design coupled with three strong magnets holds stop securely in place-much safer than using parallels which can be thrown out by centrifugal force.
- Anodized aluminum finish provides good wear-resistance.

Accommodates chuck jaws up to 2 1/8" wide.



Easily locate short parts in a 3-Jaw Chuck!

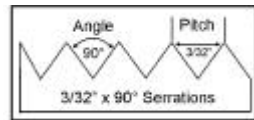


Description	Part Number	Set Price
Standard Set: 15, 20 & 25mm stops	ROY-25200	\$176.40
Deluxe Set: 15, 20, 25, 30 & 35mm stops	ROY-25210	\$307.72

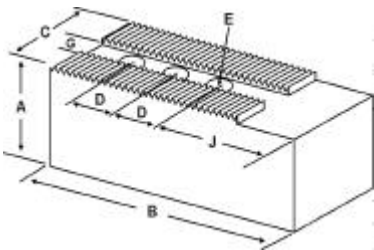
Call Us Today For All Of Your Machine Tool Needs!

# SOFT JAWS- 3/32" x 90° Serrations

For Use On: SMW Autoblok, Forkardt, Rohm, Pratt Burnerd & Other Chucks



Group  
**13**



**WARNING!**  
Make Sure you are looking for Jaws with 3/32 x 90° serrations. Jaws using 1.5mm x 60° serrations may be found on pages 10-21.

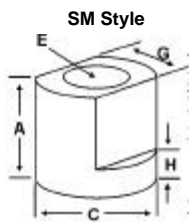
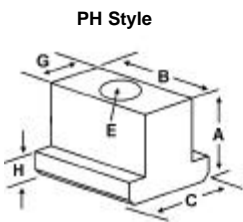


**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaws and receive a **5% DISCOUNT!**

Group No.	Critical Dimensions								ALUMINUM		STEEL	
	Groove Width G	Screw Size E	Hole Space D	Hole to Front J	Width Inch C	Length Inch B	Hght Inch A	No. of Holes	FLAT END Part Number	Price Set Of 3	FLAT END Part Number	Price Set Of 3
<b>I3-100-138</b>	1.004 (25.5mm)	20mm	1.380 (35mm)	3.500	2.50	6.50	2.50	2	FK-16250AF	97.69	FK-16250F	103.04
4.00							2	FK-16400AF	140.02	FK-16400F	147.20	
2.50							3	FK-16251AF	125.44	FK-16251F	132.48	
4.00							3	FK-16401AF	208.85	FK-16401F	220.80	
<b>I3-100-156</b>	1.000 (25.5mm)	3/4	1.562 (39.5mm)	3.250	2.50	6.50	3.00	2	SM-16300AF	111.80	SM-16300F	117.76
4.00							2	SM-16400AF	122.76	SM-16400F	133.18	
5.00							2	SM-16500AF	154.68	SM-16500F	161.92	
3.00							3	SM-16301AF	153.26	SM-16301F	161.92	
5.00							3	SM-16501AF	210.19	SM-16501F	220.80	
<b>I3-100-175</b>	1.000 (25.5mm)	.800	1.750 (44.5mm)	7.460	2.50	10.00	3.50	2	FK-25350AF*	215.95	FK-25350F*	227.26
5.00							2	FK-25500AF*	308.51	FK-25500F*	324.67	
<b>I3-110-162</b>	1.102 (28mm)	3/4	1.625 (41.5mm)	3.630	3.50	6.75	3.00	2	SM-20300AF*	217.26	SM-20300F*	215.69
5.00							2	SM-20500AF*	282.47	SM-20500F*	280.43	
3.00							2	SM-20307AF*	238.05	SM-20307F*	235.75	
5.00							2	SM-20507AF*	336.10	SM-20507F*	341.61	
<b>I3-118-250</b>	1.181 (30mm)	1.00	2.500 (63.5mm)	4.250	3.50	8.00	3.00	2	SM-24300AF	209.13	SM-24300F	220.80
5.00							2	SM-24500AF	348.53	SM-24500F	367.99	
3.00							2	SM-24301AF	265.49	SM-24301F	279.68	
5.00							2	SM-24501AF	419.87	SM-24501F	441.59	
<b>I3-118-275</b>	1.181 (30mm)	1.00	2.750 (70mm)	4.500	3.50	10.00	3.50	2	SM-40350AF*	304.97	SM-40350F*	320.94
5.00							2	SM-40500AF*	435.67	SM-40500F*	458.46	

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: FK-16250AF will be FK-16250AP. For Pointed Jaws add \$6.50.  
Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018, "B" JAWS-7075-T6 Aircraft Aluminum  
For complete list of applicable chucks, see pages 60-72. \* denotes non-stock item. Please allow 1 week manufacturing time.

## TEE NUTS & SCREWS



SM Style



Chuck Size	Forkardt	Gamet	Pratt Burnerd PBA	Critical Dimensions						1 Free Screw Included With Each Tee Nut			
				Heel Height H	Groove Width G	Screw Size E	Hght Inch A	Width Inch C	Length Inch B	Tee Nut Part Number	Price Each	Screw Part Number	Price Each
16 - 20	-	-	-	0.575	0.999 (25.5mm)	3/4" - 10 x 1.75	1.340	1.370	1.370	SM-160TN	25.24	S3/410175	3.50
15 - 24	KP/T 400-500, KS 500	DE 400	400 HYD. FRONT END	0.433	1.003 (25.5mm)	20mm	1.141	1.417	1.082	FK-160TN	59.58	M2025050	2.50
25 - 32	-	-	-	0.728	1.180 (30mm)	1" - 8	1.752	1.772	-	SM-240TN	48.37	S1008	3.50

Call Us Or Visit Our Website For Our Complete Selection!